DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027761
Date Inspected: 08-Jun-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: jobsite

CWI Name: William Sherwood

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

OBG Suspender Bracket West

This QAI observed welder Eric Sparks fit and tack weld stiffeners x464-12B into the west side of Suspender Bracket 104-W. A preheat of 150F was recorded by Tony Sherwood and verified by this QA prior to start of tack welding. The tack welding was being accomplished using the Shield Metal Arc Welding (SMAW) Process utilizing a E7018H4R consumable electrodes.

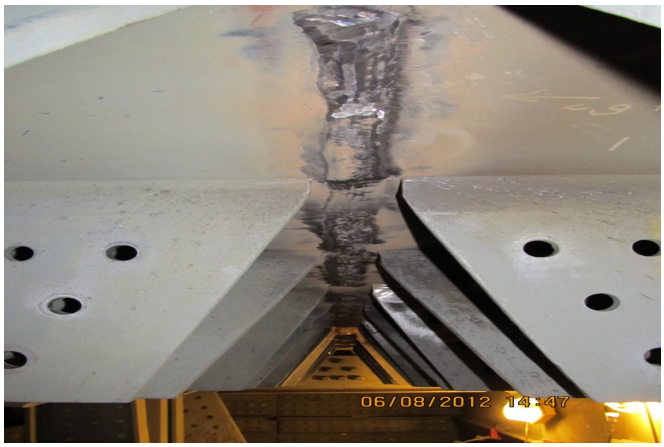
QAI observed welder Eric Sparks welding stiffeners x464-12b (2 total) to suspender bracket 104-W. A preheat temperature of 150F was achieved by use of a propane torch prior to welding. The welding was accomplished using the Shield Metal Arc (SMAW) Process, utilizing a E7018H4R consumable electrode at, as recorded by Tony Sherwood and verified by this QA, 127amps. Welding parameters recorded by the Quality Control Inspector Tony Sherwood, and verified randomly by this Quality Assurance Inspector met the requirements of applicable Welding Procedure Specification ABF-WPS-D15-F1200-A Rev-0.

OBG 13W-14W Drop-in

This QAI observed cleaning with a power wire brush by welder Mike Jiminez prior to welding a section of weld

13W-14W-W122.2. After cleaning and prior to beginning welding the welder preheated the joint to a temperature of 200F utilizing a propane fueled rose bud torch. Preheat was recorded by QC and verified at random intervals by this QAI using a Templi Stik.

When the proper preheat was achieved, Mike Jiminez began welding on the back gouged back of Deck Splice Weld 13W-14W-W122.2. Mr. Jiminez used the Shield Metal Arc Welding (SMAW) process at 125 amps recorded by Quality Control Inspector William Sherwood and verified randomly by this QAI. Welding parameters recorded by the Quality Control Inspector Tony Sherwood, and verified by this Quality Assurance Inspector, met the requirements of applicable Welding Procedure Specification ABF-WPS-D15-1040C Rev-0.



Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer